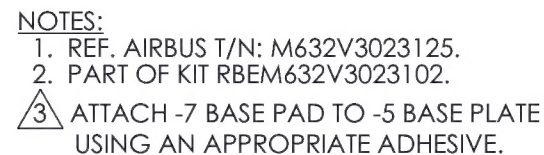


REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	7/19/2016	DPD	JAG



TITLE
UPPER SERVO CONTROL AXLE EXCHANGE

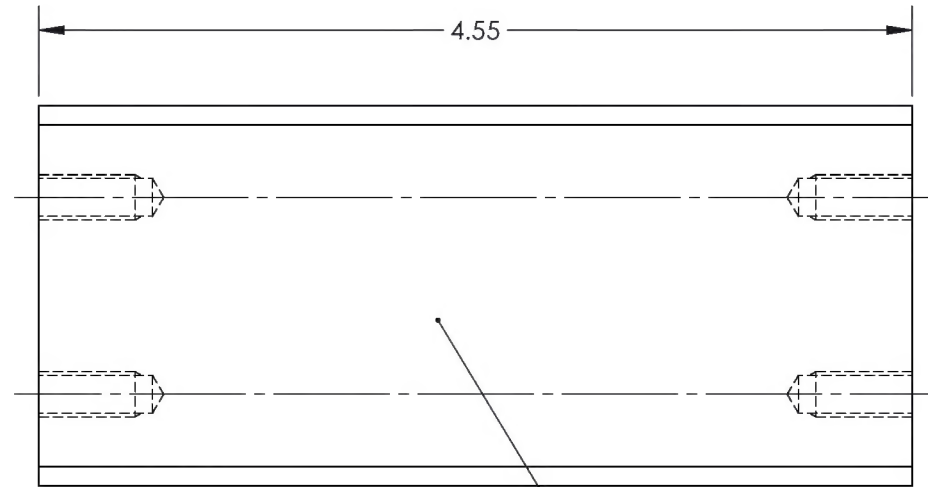
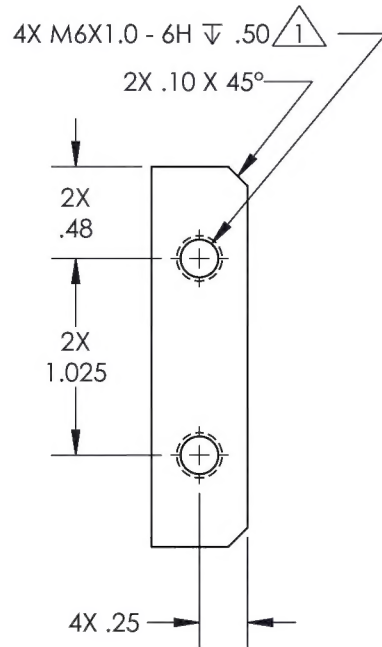
DWG NO.	RBEM632V3023125	REV 1
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ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.	RBEM632V3023125			1
									MAT'L		UNLESS OTHERWISE SPECIFIED	
									HEAT TREAT FINISH		DIMENSIONS ARE IN INCHES	
											XXX ± .005 FRACTIONS ± 1/8	
											.XX ± .01 ANGLES ± 5°	
											.X ± .1 SURFACES = 125/	
									SPEC		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
									DRAWN BY: DUERFELDT		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
									CHECKED: MACKOVJAK		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
									OPPS APPR: ANDERSON			
									QA APPR: LINDSAY		USED ON MODEL	
									APPROVED: GILBERT		H175	
									SCALE 1:2		DATE 3/24/2016	
											SHEET 1 OF 6	
			-1	1	BACK PLATE	A36/1018/1020 HR		2				
			-3	1	THREADED PLATE	A36/1018/1020 HR		3				
			-5	1	BASE PLATE	A36/1018/1020 HR		4				
			-7	1	BASE PAD	WHITE DELRIN		5				
			-9	1	FOOT	1018/1020 CR		6				
		B/O	-11	1	HEX HEAD CAP SCREW	S.S.	M8 X 1.25mm X 120mm (MCMASTER-CARR #91287A461)	1				
		B/O	-13	4	SOCKET HEAD CAP SCREW	S.S.	M6 X 1mm X 25mm (MCMASTER-CARR #91292A138)	1				

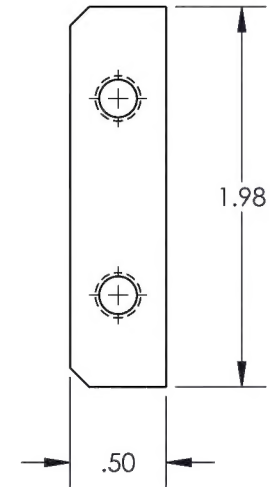
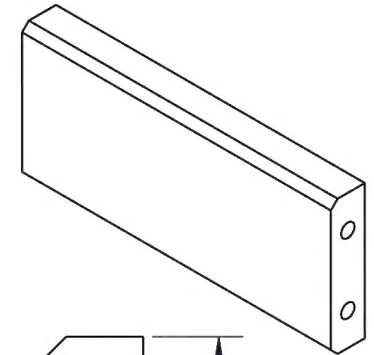
SHEET 1 OF 6

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				APPROVED



INK STAMP T/N, S/N,
"MADE IN USA"



NOTE:

1 NO POWDERCOAT THIS SURFACE.



TITLE
UPPER SERVO CONTROL AXLE EXCHANGE

DWG NO. RBEM632V3023125-1 REV 1

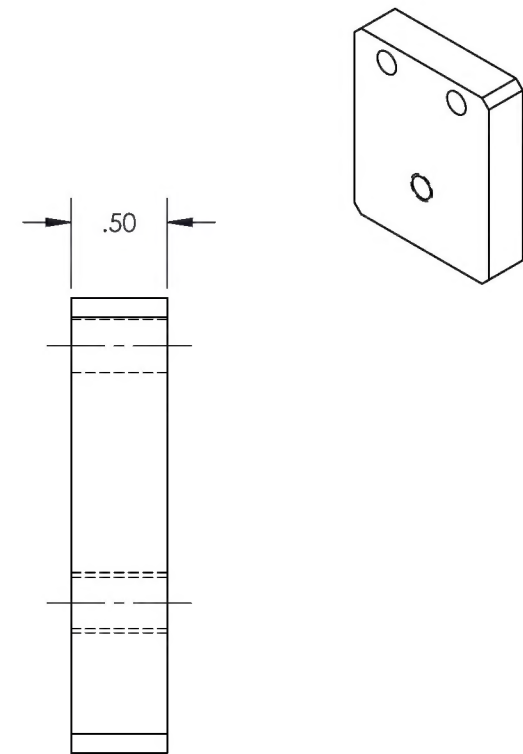
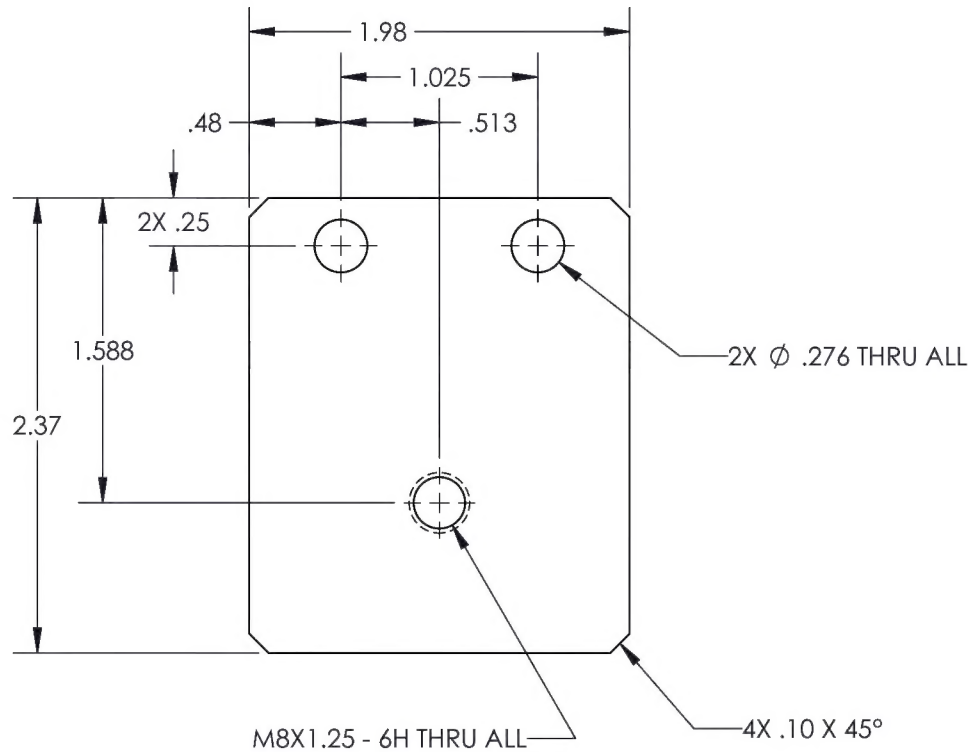
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH POWDER COAT YELLOW		.XXX \pm .005	FRACTIONS \pm 1/8
SPEC FED #13538		.XX \pm .01	ANGLES \pm 5°
		.X \pm .1	SURFACES = 125
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES	
CHECKED: MACKOVJAK		.015 x 45° OR .015R	
OPPS APPR: ANDERSON		2. DIMENSIONAL LIMITS APPLY	
QA APPR: LINDSAY		AFTER PLATING	
APPROVED: GILBERT		3. INTERPRET DIM AND TOL PER	
		ASME Y14.5M-2009	
		USED ON MODEL	
		H175	
SCALE 1:1	DATE 3/24/2016	SHEET 2 OF 6	

(-1)

BACK PLATE

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				APPROVED



M8X1.25 - 6H THRU ALL

4X .10 X 45°

2X Ø .276 THRU ALL

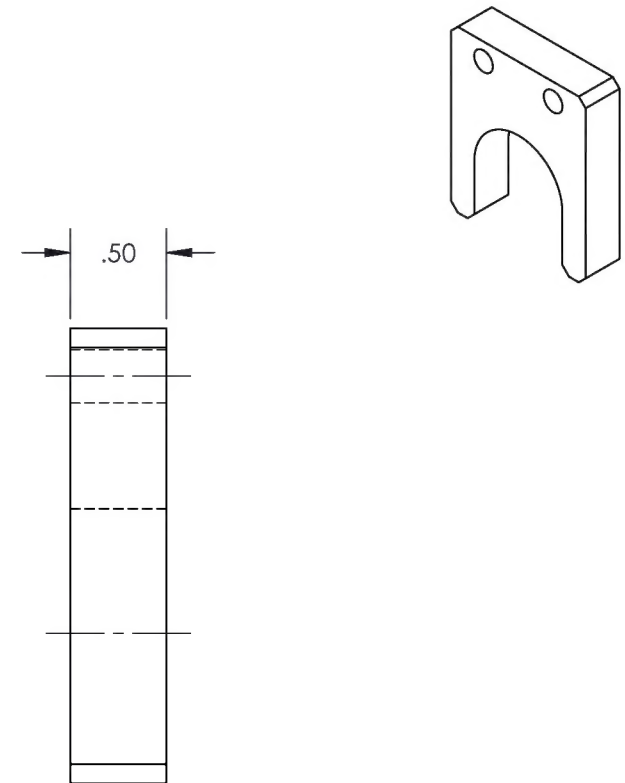
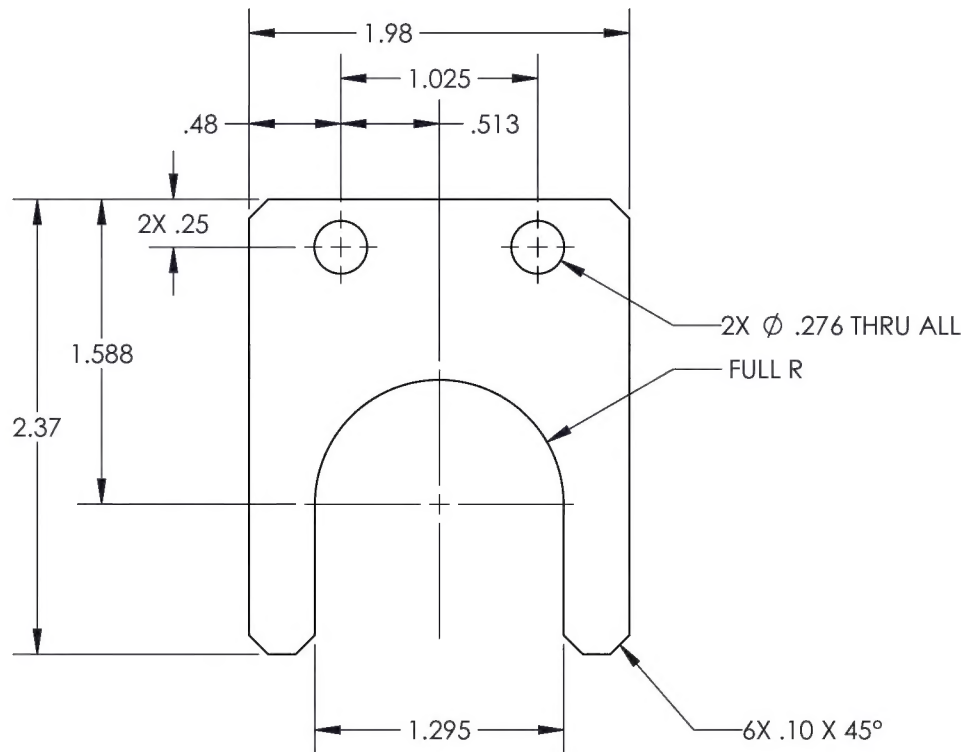
(-3)

THREADED PLATE

DART AEROSPACE	
TITLE UPPER SERVO CONTROL AXLE EXCHANGE	
DWG NO. RBEM632V3023125-3	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	.XXX ± .005 FRACTIONS ± 1/8
SPEC FED #13538	.XX ± .01 ANGLES ± .5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125°
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:1	DATE 3/24/2016
	SHEET 3 OF 6

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

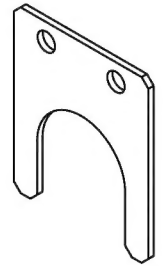
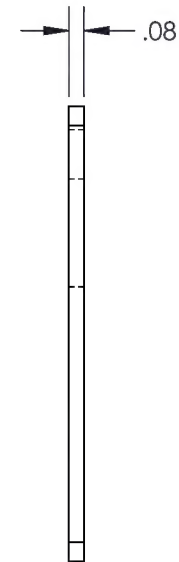
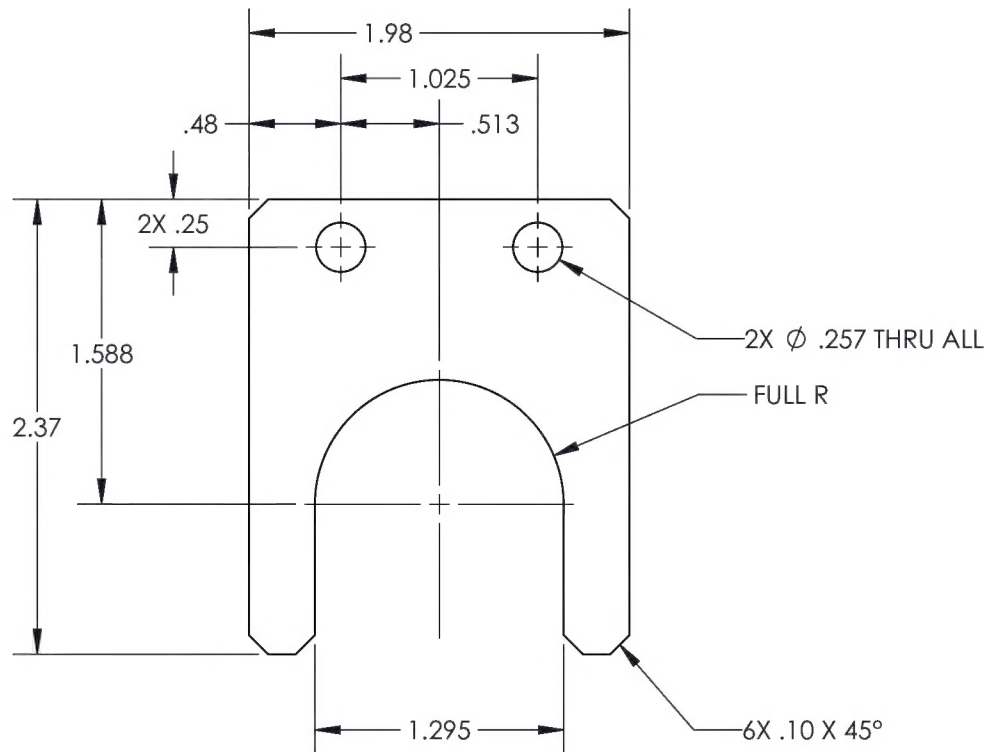


(-5)
BASE PLATE

DART AEROSPACE	
TITLE UPPER SERVO CONTROL AXLE EXCHANGE	
DWG NO. RBEM632V3023125-5	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	.XXX ± .005 FRACTIONS ± 1/8
SPEC FED #13538	.XX ± .01 ANGLES ± .5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125° ✓
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:1	DATE 3/24/2016
	SHEET 4 OF 6

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

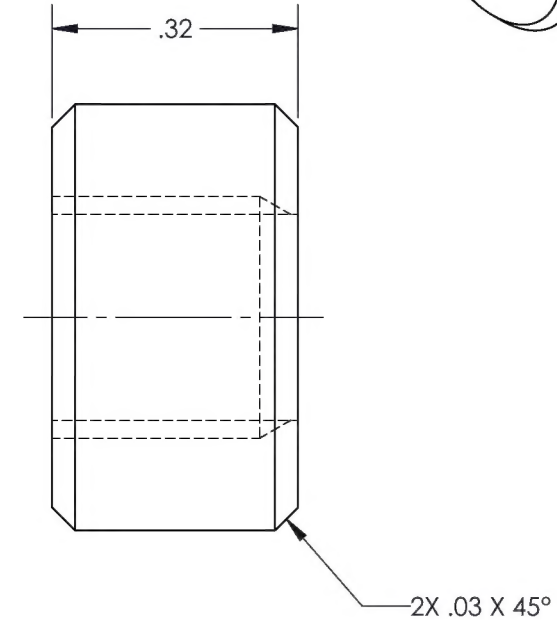
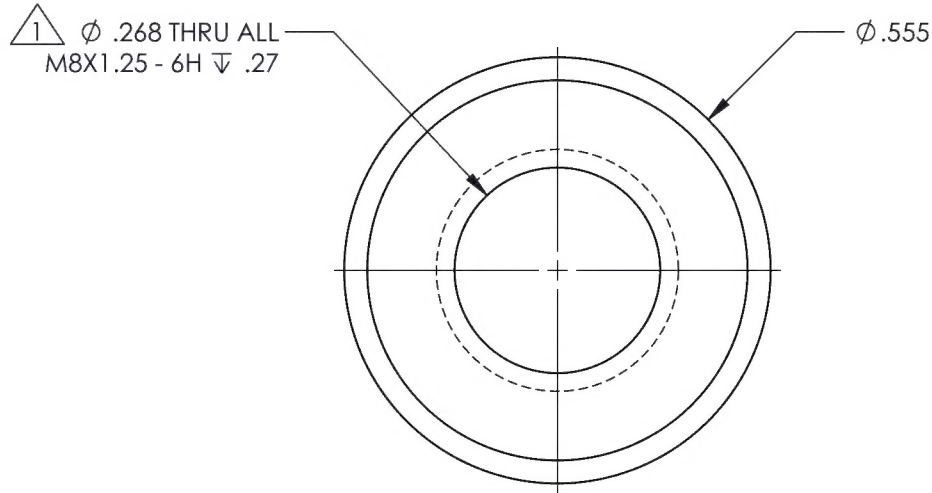
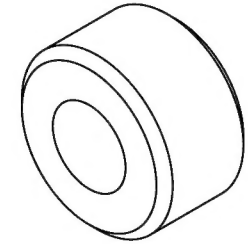


(-7)
BASE PAD

DART AEROSPACE	
TITLE UPPER SERVO CONTROL AXLE EXCHANGE	
DWG NO. RBEM632V3023125-7	REV 1
MAT'L WHITE DELRIN	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:1	DATE 3/24/2016
	SHEET 5 OF 6

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



NOTE:

1 Δ NO POWDER COAT THIS SURFACE.



TITLE
UPPER SERVO CONTROL AXLE EXCHANGE

DWG NO. RBEM632V3023125-9 REV 1

MAT'L 1018/1020 CR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH POWDER COAT YELLOW		.XXX ± .005	FRACTIONS ± 1/8
SPEC FED #13538		.XX ± .01	ANGLES ± .5°
DRAWN BY: DUERFELDT		.X ± .1	SURFACES = 125 ✓
CHECKED: MACKOVJAK		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 4:1		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 3/24/2016		USED ON MODEL	
		H175	
		SHEET 6 OF 6	

(-9)
FOOT